

Date: Tuesday, 23/12/2008 9:43:03 AM
 User: Julie Dawson

40087
 Keeping original B# **Process Sheet**

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2582
Job Number	: 44267		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: REWORK20
This Issue	: 23/12/2008 S.O. No. :	Drawing Number	: NCR08-124
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 30/12/2008 Qty: 14 Um: Each
Checked & Approved By	: <u>JUD 08.12.23</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2582	Step Leg Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
 Step Leg Assembly
 Pull from stock
 Qty 14 of B40087

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

CAREFULLY remove all rivets on the D2279, to not enlarge or ovalize the holes.

*** Remove the rivet head, and carefully punch out the remainder of the rivet, to avoid drilling right through***

Touch up holes with alodine as necessary

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Pick the following

5.0	MS20470AD44	Rivet, Universal Head
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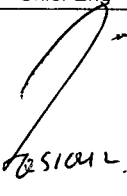
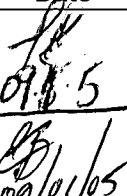
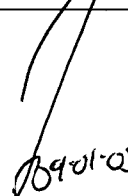
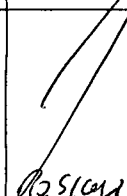
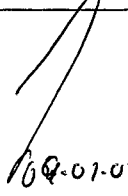
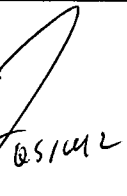

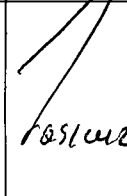
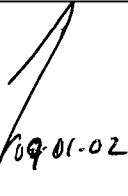


Comment: Qty.: 10.0000 Each(s)/Unit Total : 140.0000 Each(s)
 Rivet, Universal Head

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/01/07

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0802-02	20	Part, D2278 needs 2 rivet holes filled with weld. slightly ob+round. Hit with punch while R.C. removing rivets for re-work		Fill the 2 affected holes with weld per QSI 004 & bring smooth & flat. Transfer drill & debur holes.	 09/01/05	 0901-05		 09-01-02
				Touch-up with plodine per QSI 005.	 09/01/05			 09-01-02

NOTE: Date & initial all entries

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D2582

Job Number: 44267

Part Number: REWORK20

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2279

Step Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
Step Spacer

*** Pick if necessary***

B. _____

Qty: _____

Handwritten: 2/4

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2582 and

Handwritten: 09/01/06 (14)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09/01/06 (14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WA

Keep Original Batch number

Handwritten: SAD 09-01-07 (14)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 09/01/07 MF 09-01-07

Job Completion



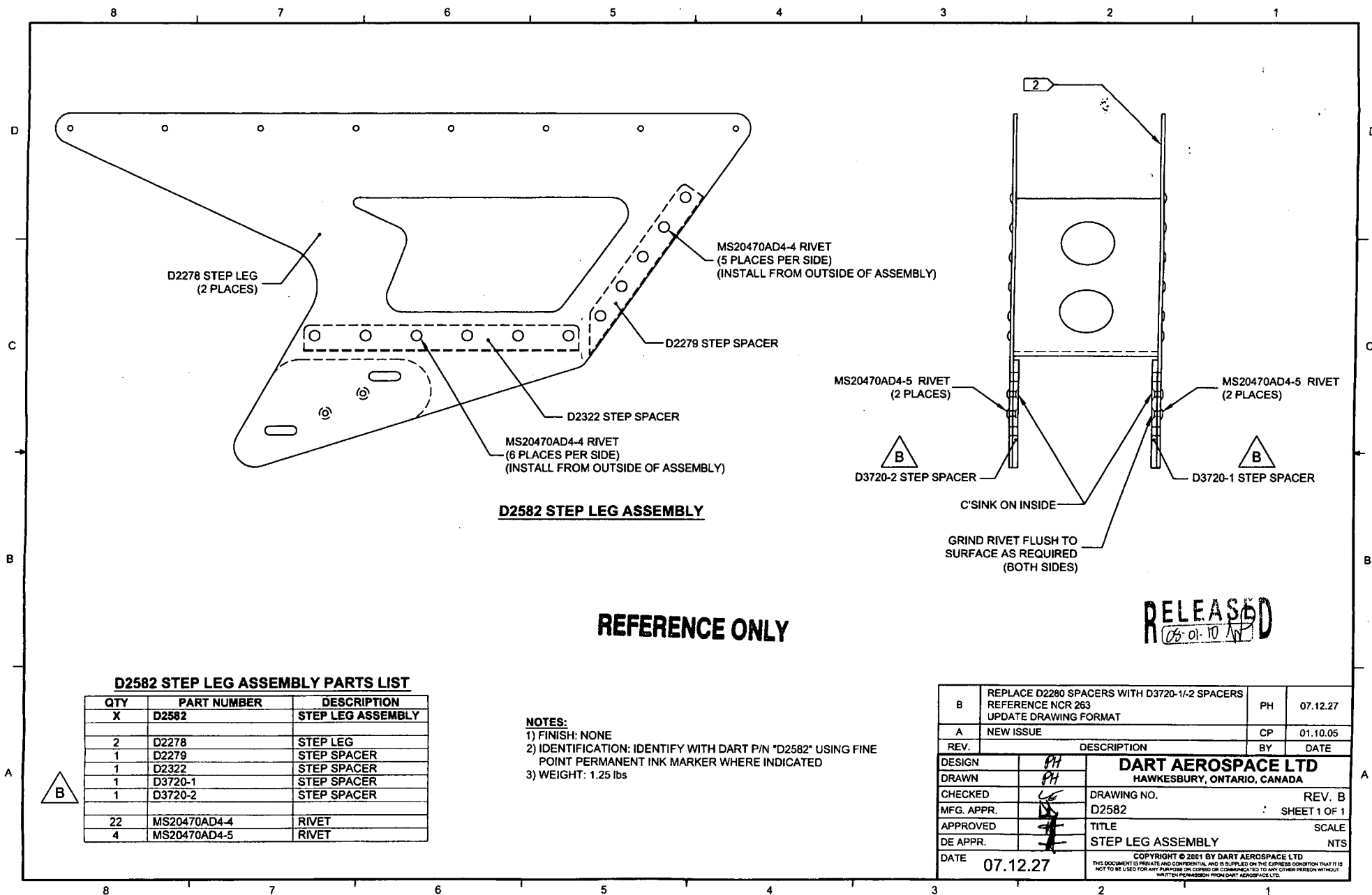
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2582 STEP LEG ASSEMBLY

REFERENCE ONLY

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs

B	REPLACE D2280 SPACERS WITH D3720-1/2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED	LE		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.12.27		

RELEASED
05-01-10

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D2582 SHEET 1 OF 1
TITLE SCALE
STEP LEG ASSEMBLY NTS

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